

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave.St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008650**Date Inspected:** 18-Aug-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai,China**CWI Name:** Lv Li Qing / Shen Fu You**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Assembly**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Tim McClendon was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

OBG Bay No. 14

On assembly 9BE SEG 052C the QA inspector observed two (2) crack tacks on Longitudinal Diaphragm LD 004 - 039 weld number 039. The tack welds appear to have cracked after the fit-up process and prior to welding the fillet weld. See photographs for additional information.

Flux Cored Arc Welding (FCAW) of Longitudinal Diaphragm to Floor Beam for SEG 52 weld number 024 for Segment 9BE. The ZPMC welder identified as 044795 was welding in the 3G position. The ZPMC QC identified as Guo Xing Hui was monitoring the welding and recording the weld variables. The welding variables recorded by ZPMC QC appeared to comply with the WPS-B-T-2233-Tc-U4L-F.

Flux Cored Arc Welding (FCAW) of Longitudinal Diaphragm to Floor Beam for SEG 52 weld number 033 for Segment 9BE. The ZPMC welder identified as 055491 was welding in the 3G position. The ZPMC QC identified as Guo Xing Hui was monitoring the welding and recording the weld variables. The welding variables recorded by ZPMC QC appeared to comply with the WPS-B-T-2233-Tc-U4L-F.

# WELDING INSPECTION REPORT

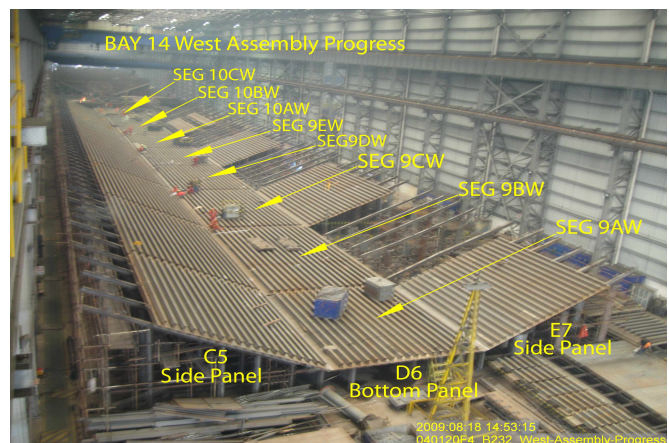
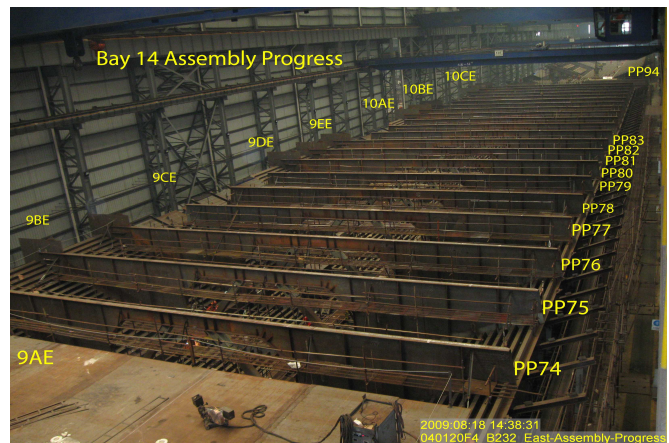
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Flux Cored Arc Welding (FCAW) of Longitudinal Diaphragm to Floor Beam for SEG 52C weld numbers 001 and 002 for Segment 9BE. The ZPMC welder identified as 044795 was welding in the 1G position. The ZPMC QC identified as Guo Xing Hui was monitoring the welding and recording the weld variables. The welding variables recorded by ZPMC QC appeared to comply with the WPS-B-T-2231-Tc-U4b-F.

Flux Cored Arc Welding (FCAW) of Longitudinal Diaphragm to Bottom Panel for SEG 52C weld number 026 for Segment 9BE. The ZPMC welder identified as 214945 was welding in the 12F position. The ZPMC QC identified as Guo Xing Hui was monitoring the welding and recording the weld variables. The welding variables recorded by ZPMC QC appeared to comply with the WPS-B-T-2232.

Currently all Floor Beam components are installed in East fixture of bay 14 and majority of side panels and bottom panels are installed in west fixture of bay 14. See the photographs for more information on the components located in east and west assemblies.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

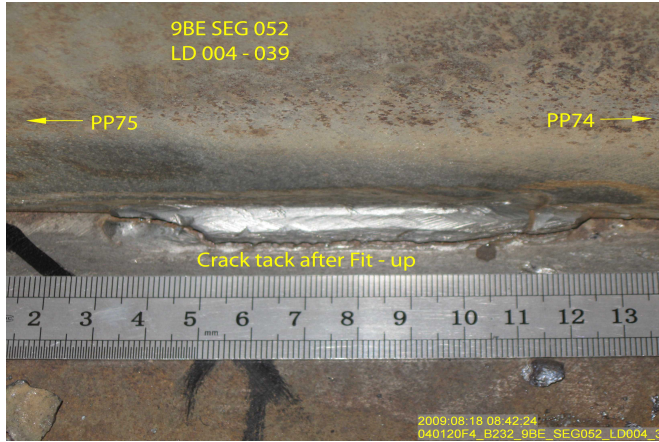


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## WELDING INSPECTION REPORT

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### Summary of Conversations:

No relevant conversations spoken on this date.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (15000422372), who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	McClendon, Timothy	Quality Assurance Inspector
<b>Reviewed By:</b>	Patterson, Rodney	QA Reviewer

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